Work Order ID 70325

Thursday, June 02, 2011 2:49:56 PM

Item ID:

D3272-1

Revision ID: Item Name:

Step

Start Date:

6/8/2011

Start Oty: 10.00 Req'd Oty: 10.00

Required Date: 6/17/2011

Reference:

Process Plan: Approvals:

QC:

Date:

Date:

1

SPC (Y/N):

Set Up/

Run Hours

Tooling:

0.00

0.00

Accept

Tool ID

Cust Item ID:

Customer:

Date:

Date:

Tool # Plan Code

Accept Qty

Reject Qty

Setup Start

Stop

Start

Stop

Number

Insp. Stamp

Draw Nbr D3272

Sequence ID/

Work Center ID

Rev B

100

Large Fab

Large Fab

Large Fab

Operation

Revision Nbr

Description

Memo

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

110

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo r

0.00

A.E 11.06.06

Run

Dart Ae W/O:			— <u>"</u>	ORK ORDER CHANG	GES			<u></u>
DATE	STEP	PROCEDURI				Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:						
NCR:				DER NON-CONFORM				
DATE	STEP	Description of NC Section A	Initial	Action Description	Sign Date		Approval Chief Eng	Approval QC Inspecto
			Chief Eng	Chief Eng	Date			
		•						'

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 70325

Thursday, June 02, 2011 2:49:56 PM

Ite	m	ID	:

D3272-1

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Required Date: 6/17/2011

Step

6/8/2011

Start Oty: 10.00 Req'd Qty: 10.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Set Up/

Date:

Stop

Reject

Oty



Sequence ID/ Work Center ID

120

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: WA

Run Hours

0.00

0.00

Tool # Plan

Code

Accept

Oty

Reject Number

Insp. Stamp

130

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

N161878

Dart Ae	rospace	Ltd								•
W/O:				V	VORK ORDER CHANGE	S		····	· · · · · · · · · · · · · · · · · · ·	
DATE	STEP	PRO	OCEDUR	E CH	HANGE	Ву	By Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						3				
Part No):	PAR #:	Fau	It Ca	itegory:	NCR: Yes	No DQ	A:	Date: _	
Resolution:		Dis	posit	tion:	QA: N/C Closed:			Date: _		
NCR:		,	WORK	OR	DER NON-CONFORMAN	ICE (NC	R)			
		Description of NC			Corrective Action Section	В	Verific	cation	Approval	Approval
DATE	STEP	Section A	Init Chief		Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
									9	
										<u>}</u>

Picklist Print

Thursday, June 02, 2011 2:49:53 PM

Work Order ID: 70325

Parent Item:

D3272-1

Parent Item Name:

Step



Location |

HALL

WA

Start Date: 6/8/2011

Required Date: 6/17/2011

Start Oty: 10.00

Required Oty: 10.00

Comments:

IPP Rev:A

New Issue 07-06-09

Manufactured

JLM

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Bin Primary Item Location Last Location Route Seq ID

Unit of Measure Hand

Qty on

Qty per Kit Total Oty

Qty Issued

Date Status Issued

D2622-120C

Step Extrusion

No

64409

46910

66970

100

Loc Qty

6

6

2

57.7

55.7

Each

63.7000

Loc Code

Page 1

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W/O:			WC	RK ORDER CHANGE	S			
DATE	STEP	PRO	OCEDURE CHAI				Qty Approval Chief Eng / Prod Mgr	Approva QC Inspector
Part No		PAR #:						
							Date	
NCR:		·	WORKORDI	ER NON-CONFORMAN	NGE (NCH	()		
		Description of NC	Corrective Action S		В	Verification	Approval Chief Eng	Approva
DATE	STEP	Description of NC Section A	Init al Chief Eng	Action Description Chief Eng		Section C		QC Inspecto

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



DESIGN DRAWN BY			DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
	CHEC	ÇED	APPROVED	DRAWING NO. REV.	В				
	(E	#	D3272 SHEET 1 OF	3				
	DATE			TITLE SCAL	Ε				
	07.0	5.18		STEP ASSEMBLY, HI LONG NT	s				
	Α		04.03.01	NEW ISSUE					
	В		07.05.18	D3272-1 WAS D2622-120					

RELEASED 0706 04

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
Х		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
·	Х	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
			3
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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Dart Aerospa	ce Ltd
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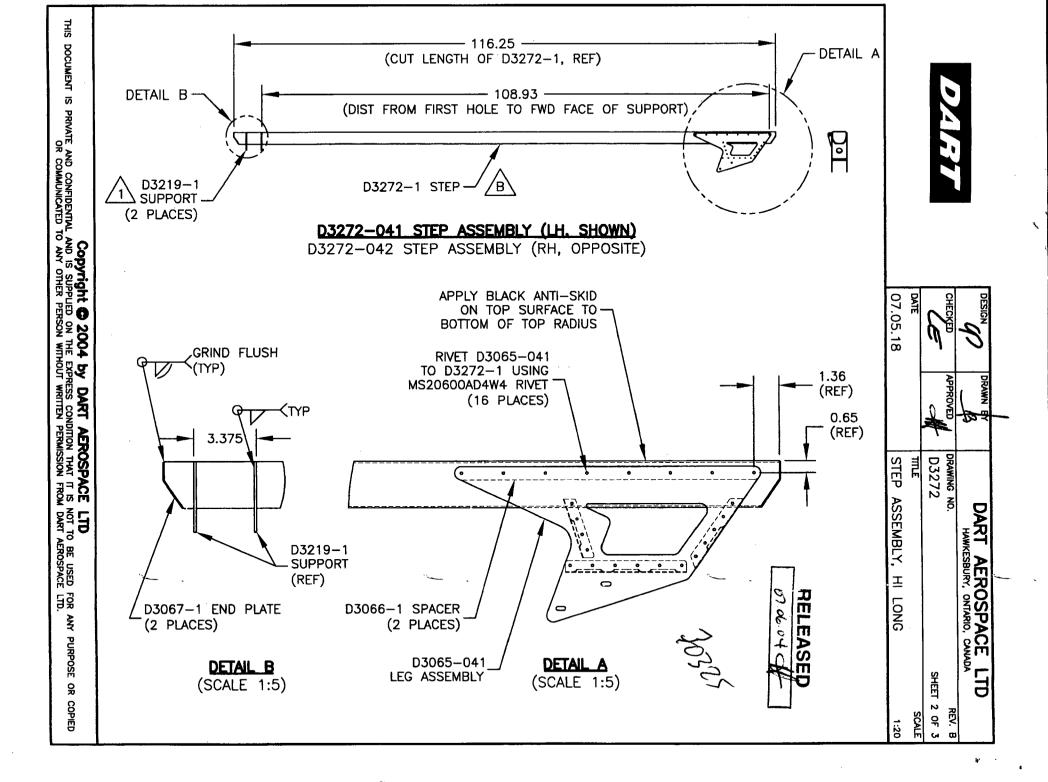
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DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
					•						
		·									
Part No):	PAR #: Fault Category:	NC	R: Yes	No DQ	\ :	Date:				

QA: N/C Closed: _____ Date: ____

Resolution: _____ Disposition: ____

NCR:	à		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action	Section B		Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Descrip	ion	Sign & Date	Section C	Chief Eng	QC Inspector	
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NOTE: Date & initial all entries



Dart Aerospace Ltd	Dart	Aeros	pace	Ltd
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W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	:	PAR #:	Fault Category:	NC	R: Yes	No DQ	А:	Date:				

QA: N/C Closed:

Date: _____

Disposition: ____

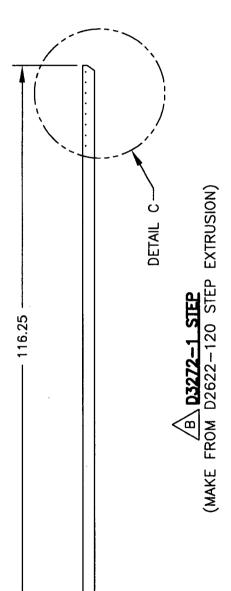
NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action	Section B		Verification	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Descrip	tion	Sign & Date	Section C	Chief Eng	QC Inspector			
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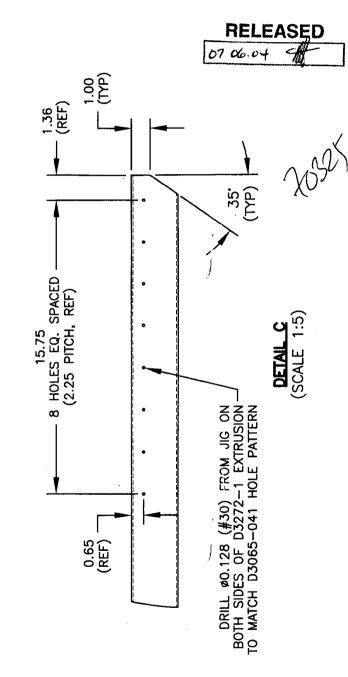
NOTE: Date & initial all entries

Resolution:



DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	
CHECKED	APPROVED /	DRAWING NO.	REV. B
LE		D3272	SHEET 3 OF 3
DATE		TITLE	SCALE
07.05.18		STEP ASSEMBLY, HI LONG	1:20





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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		_ PAR #:	Fault Category:	NCR: Yes No DQA:	Date:	
	Resolution:		Disposition:	QA: N/C Closed:	Date:	

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DATE STEP	Description of NC		Corrective Action		Section B		Approval	Approval
	Section A	Initial Chief Eng	Action Descri Chief Eng	otion	Sign & Date	Section C	Chief Eng	QC Inspector
				-			•	
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	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description	STEP Description of NC Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Description A Description Section B Section B Section C Chief Eng